

split

Work Order ID 51096 - 1



July 31, 2009 2:30:51 PM

Item ID: D3687-3

Accept



Setup Start



Revision ID: B

Item Name: MOUNT

Stop



Start Date: 8/11/09 Start Qty: 25.00



Cust Item ID:

Required Date: 8/11/09 Req'd Qty: 25.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3687

Rev B

100

0.00



Outsource1

Memo

0.00

Outsource process - Heat Treat

Send M174B3937X4750 For heat treating  
to CONDITION H-900(to become M174PHH900B3937X4750)  
FTU IN EXCESS OF 190 KSI  
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

CL 09/08/07 188t

105

0.00



Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O: 10165  
Machine as per Dwg D3687  
Possible Supplier: Globus Precision  
Conformity sheet required

CL 09/08/04 25

issue P/O: 10482  
LPI

CL 09/09/28 (6)

# Work Order ID 51096

July 31, 2009 2:30:51 PM



Page 2

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

rec'd + inspect m/ 09 09 28

8/9/21 (6)

8/9/28 (6)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

27 8/10/28

(46) 6

(PT) ->

130 8/6/0

Identify as per dwg & Stock Location: 118

0.00



Packaging

Memo

0.00

Packaging

(6x)

11/8/28 SP

(PD) ->

W/O: 51096		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	*130	-issue P/O for Liquor Penetrant P/O # 10482	CL	09/09/23	(6)		
	*140	-Review part ensure NDT Results are attached	CL	01/9/28	(6)		
	*150	-QCS inspect results and condition of parts	MM	09/09/28	(6)		S 09/07/25

Part No: D3687-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 51096

July 31, 2009 2:30:51 PM



Page 3

Item ID: D3687-3

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Start Date: 8/11/09 Start Qty: 25.00

Required Date: 8/11/09 Req'd Qty: 25.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/29 *[Signature]*  
MF 09-09-29

# Picklist Print

July 31, 2009 2:30:50 PM

Page 1

Work Order ID: 51096

Parent Item: D3687-3RevB

Parent Item Name: MOUNT


Comments:

Start Date: 8/11/09

Required Date: 8/11/09

Start Qty: 25.00

Required Qty: 25.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750		Purchased	No			100	f	3.0000	8.7711			
												
17-4SS Bar H900-3.937x4.750												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

110875

111100

m112374

3

2.9

0.1

mf 09-09-29

D3687-3P

Purchased

No

105

Each

0.0000

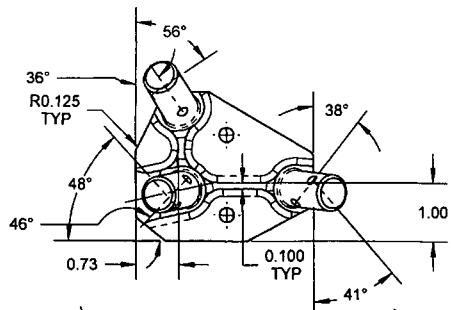
25.0000



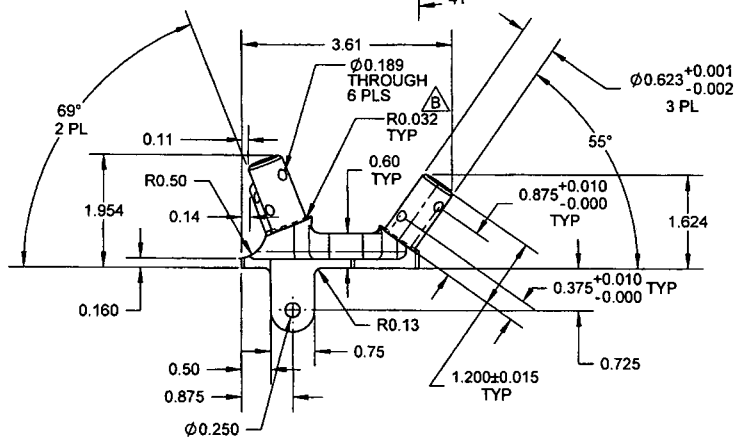
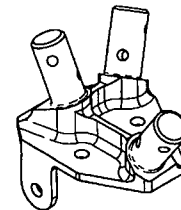
MOUNT



Pc 9/9/21 (6)

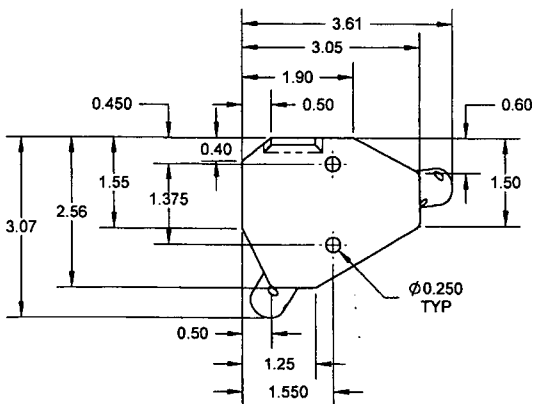


W/O 51096  
~~50937~~ u



**D3687-1 MOUNT**

**RELEASED**  
 08/11/15



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.81 lb
  - 8) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	21	D3687	SHEET 1 OF 2
APPROVED	1	TITLE	SCALE
DE APPR.	1	MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

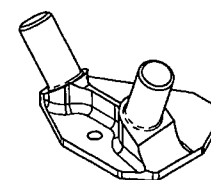
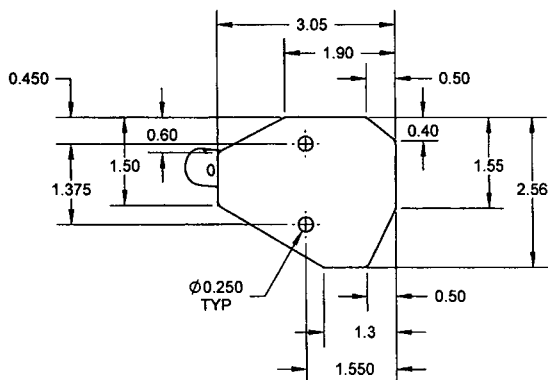
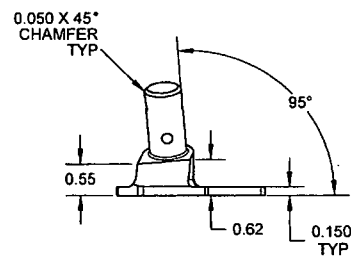
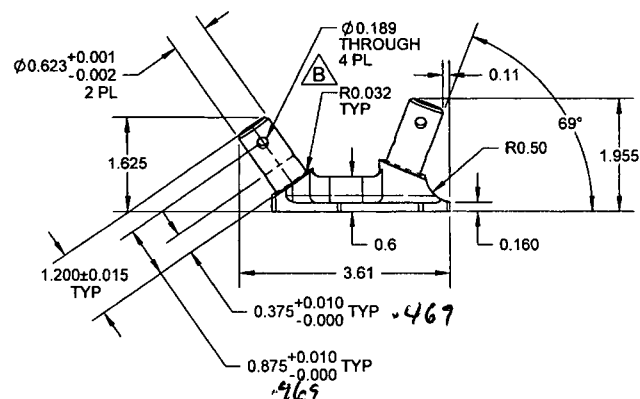
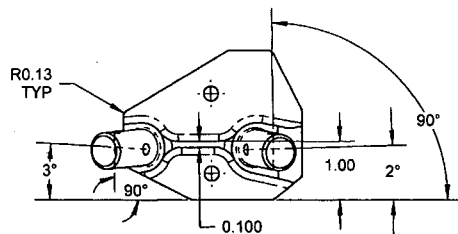
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



51096

- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.64 lb
  - 8) LPI PER ASTM 1417 LEVEL 2

**D3687-3 MOUNT**

**RELEASED**  
08/12/15

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3687	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Metcor Inc.  
 560, boul. Arthur-Sauvé  
 St-Eustache (Québec) J7R 5A8  
 Tél.: (450) 473-1884  
 Fax Administration: (450) 491-5498  
 Fax Production : (450) 491-6454

## Rapport d'inspection

Order	Load
149974	1

Customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

Shipped To:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number		
10126		17-4PH				
<p align="center"><b>PROCESSING SPECIFICATIONS</b></p> <p>AGE HARDEN          CONDITION H 900          SAE AMS 2759/3 REV.E</p>						
Requirement	Specified	Tests Performed	Test Results			
HARDNESS	40 - 47 HRC	28	43 - 45 HRC			
Quantity	Weight	Part Number / Part Description				
28	1447	BARRE RONDE 8 BARRES DE 7" + 16 BARRES DE 48" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 58" BAR 3.937 X 4.750 1 PALETTE				

### COMMENTS

INSPECTOR:

*[Signature]*



DATE: 2009-08-04

# Certification

Order	Load
149974	1

Customer 215  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY ON K6A 1K7

Shipped To:  
DART AEROSPACE  
1270 ABERDEEN

HAWKESBURY ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
10126		17-4PH		

## PROCESSING SPECIFICATIONS

AGE HARDEN  
CONDITION H 900  
SAE AMS 2759/3 REV.E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	40 - 47 HRC	28	43 - 45 HRC

Quantity	Weight	Part Number / Part Description
28	1447	BARRE RONDE 6 BARRES DE 7" + 18 BARRES DE 48" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 58" BAR 3.937 X 4.750 1 PALETTE

Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 AGE HARDE	900 +/-10°F	1 hrs -0 +3 MIN	air			635	08-03-09	10:15	12:30	08-03-09
4.00 HARDN INS										
5.00 FINAL INSP										08-04-09

## COMMENTS

APPROVED BY:

*Anthony Bessoneau*



DATE: 2009-08-05

We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO10165

Purchase Order Date 8/04/09

PO Print Date 8/04/09

Page Number 1 of 1

Order From :

VC-GLO001

GLOBUS PRECISION INC.  
36 COLONNADE RD. N.  
NEPEAN, ON K2E 7J6  
CA

**FAKED**  
09/16/09

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 226 1579	Requisition Nbr	
Vendor Fax	613 226 1719	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extenc Pr
1	D3687-1P	MOUNT	8/19/09 Yes	<i>New</i> 6 <sup>25</sup> / <sub>25.00</sub> Each	Purolator ground	\$400.0000	\$10.00
Special Inst:			AS PER DWG D3687 REV. B B51097				
2	D3687-3P	MOUNT	8/19/09 Yes	<i>New</i> 6 <sup>25</sup> / <sub>25.00</sub> Each	Purolator ground	\$295.0000	\$7.37
Special Inst:			AS PER DWG D3687 REV. B B51096				

PO Total: \$17.37

*RUSH*

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 8/04/09

*CL*  
*W*  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



## LIQUID PENETRANT TEST REPORT

P- 14954

ION	DATE	PAGE	1	OF	1	
IS	ACUREN JOB No.	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
T	PO/NO No.	WORK LOCATION				
EXAMINED	ACCEPTANCE STD.	REV./DATE				

DAT Aerospace  
LINDA/CHANTEL  
1270 ABELDEEN ST.  
HAWKESBURY ON.  
K6H 2K7  
F.P.I. ON MACHINED PARTS AND  
CROSS TUBES.

SEPT 28-2009  
188-09-001561  
- 10482  
HAWKESBURY  
ASTM 1417  
2009

DESCRIPTION	PROCEDURE No.	LT	REV./DATE	TECHNIQUE No.	LT	REV./DATE
-------------	---------------	----	-----------	---------------	----	-----------

STAINLESS STEEL AND MATERIAL ALUMINUM THICKNESS  
WET FLUORESCENT LIQUID PENETRANT INSPECTION  
CARRIED OUT 100% EXTERNAL

DETAILS	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
---------	---	----------------------------------	--	--	--

BRAND 2607 - MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc

ANT 2607 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE

ANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LAPINO

PER SKO 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE 07.8-2009

PER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

SURFACE	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
---------	------------------------------------	------------------------------------	--	---------------------------------------	--

E TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

TS- ☒ METRIC ☐ IMPERIAL

<ul style="list-style-type: none"><li>- W.O. 51882 - CROSS TUBE ✓</li><li>- W.O. 51881 - CROSS TUBE ✓</li><li>- W.O. 52334 - CROSS TUBE ✓</li><li>- W.O. 52335 - CROSS TUBE ✓</li><li>- W.O. 52495 - MOUNTS ✓</li><li>- W.O. 51096 - MOUNTS ✓</li><li>- W.O. 51097 - MOUNTS ✓</li></ul>	<ul style="list-style-type: none"><li>- AN INSPECTION WAS DONE ON W.O. 52470 - ONE ITEM WAS REWORKED DUE TO HOLE SIZE AT BRACKET.</li><li>- EXAMINATION OF THIS AREA WAS CARRIED OUT AND RESULTS AS FOLLOWS</li><li>- FOUND ACCEPTABLE TO CODE</li></ul> <p><u>WAT 090828</u></p>
---	---

Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

REPRESENTATIVE	Eric Downing	DTR #	E-27840
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DIAN (SIGNATURE): Mike Johnston REPORT REVIEWED BY: NAME INITIALS

1<sup>ST</sup> TECHNICIAN CGSB LEVEL 2 SNT LEVEL 2 CGSB REG. NO. 6066

2<sup>ND</sup> TECHNICIAN CGSB LEVEL \_\_\_\_\_ SNT LEVEL \_\_\_\_\_ CGSB REG. NO. \_\_\_\_\_

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